

Work Order ID 77462 -1

Thursday, December 08, 2011 6:22:01 AM

\*77462\*

Soon

Page 1

Item ID: D3859-041

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearplate

Start Date: 12/8/2011 Start Qty: 2.00 \*2\*

Required Date: 12/12/2011 Req'd Qty: 2.00 \*2\*

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: *MMF*

Date: 11-12-08

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject  
Qty Qty Number Insp.  
Stamp

Draw Nbr

Revision Nbr

100

0.00

\*100\*

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3859 Dwg Rev: A Prog Rev: A 2-  
Deburr if necessary

*34 053*

110

0.00

\*110\*

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

120

0.00

\*120\*

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

*8 mizlo*

*(A)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 77462

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Setup Start **\*NS1\***

Revision ID:

Item Name: Wearplate

Stop **\*NS2\***

Start Date: 12/8/2011 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 12/12/2011 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

0.00

**\*130\***

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld D3009-3 cups as per dwg D3859 A/R 316L stainless steel rod  
Batch: M114508 2-Weld hard facing as per Dwg D3859 A/R  
2059B Hard Coat rod Batch: M119615 \*\*\*\*\*use  
DT9462 for welding\*\*\*\*\*

*EL 11.12.13 (24)*

140

QC9- Inspect visual per QS1004- Fusion Welds

0.00

**\*140\***

QC

Memo

0.00

Quality Control

*PC 11.12.14 4x Ø*

150

QC5- Inspect part completeness to step on W/O

0.00

**\*150\***

QC

Memo

0.00

Quality Control

*S 11.12.14*

*(24)*

W/O:		WORK ORDER CHANGES					
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# Work Order ID 77462

Thursday, December 08, 2011 6:22:01 AM

**\*77462\***

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Item ID: D3859-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Wearplate

Start Date: 12/8/2011 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 12/12/2011 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

160

Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3

0.00

**\*160\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

3200F

FINISH TIME:

3:45

4xØ m-11/12/14

170

QC3- Inspect Part Finish

0.00

**\*170\***

QC

Memo

0.00

Quality Control

H 11-12-14

180

Identify as per dwg & Stock Location:

0.00

**\*180\***

Packaging

Memo

0.00

Packaging

PP 77543

4x

11-12-20 SP



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 77462**

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Item ID: D3859-041

Revision ID:

Item Name: Wearplate

Start Date: 12/8/2011 Start Qty: 2.00

Required Date: 12/12/2011 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

190

**\*190\***

QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/  
Run Hours

0.00

0.00

Accept

**\*N9000040100\***

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11/12/2011  
MF 11-12-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Thursday, December 08, 2011 6:22:00 AM

Page 1

Work Order ID: 77462  
Parent Item: D3859-041  
Parent Item Name: Wearplate

Start Date: 12/8/2011  
Start Qty: 2.00

Required Date: 12/12/2011  
Required Qty: 2.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	237.6000	0.85	1.7	16.1	12-12-8	

Location

MAT020

119653

Loc Qty

237.6

237.6

Loc Code

119653

~~119653~~

9

130

Each

39.0000

6

12

EL 11-12-12

Location

WA030

73699

Loc Qty

39

39

Loc Code

24 - ~~33~~

Missing  
end of stock

D3009-3

Cop

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3859-041	WEARPLATE
2	1	D3859-1	WEARPLATE
3	6	D3009-3	CUP

2059B HARDCOAT  
10 PL

0.06  
TO  
0.13  
HIGH

C  
SYM

0.38

1.0  
TYP

3.1  
TYP

1.50  
REF

1.00

HARDCOAT WELD  
SURFACING  
REF

6 PL  
1/32

6

D3859-1 WEARPLATE (1)

INSTALL D3009-3 FLUSH  
WITH THIS SURFACE  
TYP

D3009-3 CUP (6)

D3859-041 WEARPLATE

RELEASED  
09.01.26

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3859-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.46 lbs
- 8) WELD PER DART QSI 004

A	NEW ISSUE		BY	09.01.26
REV	DESCRIPTION		DATE	
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.01.26			

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
D3859

TITLE  
WEARPLATE

REV. A  
SHEET 1 OF 2

SCALE  
NTS

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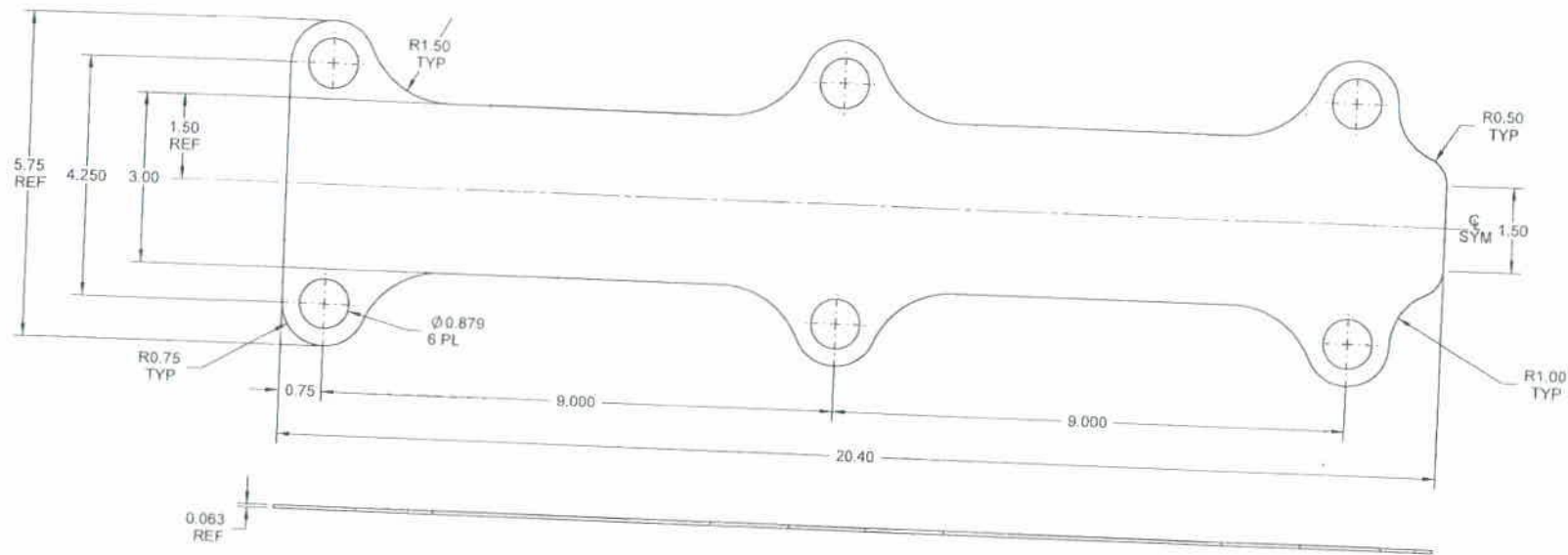
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



D3859-1 WEARPLATE

NOTES

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK), PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.29 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. D3859	REV. A
CHECKED		TITLE WEARPLATE	SHEET 2 OF 2
MFG. APPR.		SCALE	NTS
APPROVED		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR FOR DISSEMINATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DE APPR.			
DATE	09.01.26		

RELEASED  
# 77460  
09.01.26



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